

Work Order ID: 55963

February 8, 2010 11:41:53 AM

Page 1

Item ID: D4055-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Tank Top

Start Date: 2/08/10 Start Qty: 3.00

Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

PAT Rev. A

100

0.00

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11330
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required

PL 10-2-08
(3)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

PL 11/3/14 (3)

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

8 10/12/10 to Prelim Dwg only as

no change from PA1 to "Rev A" Dwg
8 10/12/10 (not to be released Dwg)

QC APPROVAL

PRELIMINARY ISSUE

2

10/16/23

Work Order ID 55963

February 8, 2010 11:41:54 AM

Page 2

Item ID: D4055-1

Accept

Revision ID:

Item Name: Tank Top

Start Date: 2/08/10 Start Qty: 3.00

Required Date: 2/22/10 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging



N/A EL 10.03.08

Label Shelf

Free/10.04.13

488

10-6125 (30)

(3)

SP

Work Order ID 55963

February 8, 2010 11:41:54 AM



Page 3

Item ID: D4055-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Top

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

10/06/28 J

PS-10-11-14

(3)

West

Picklist Print

February 8, 2010 11:41:50 AM

Page 1
T

Work Order ID: 55963



Parent Item: D4055-1



Parent Item Name: Tank Top



Start Date: 2/08/10

Required Date: 2/22/10

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Start Qty: 3.00

Required Qty: 3.00

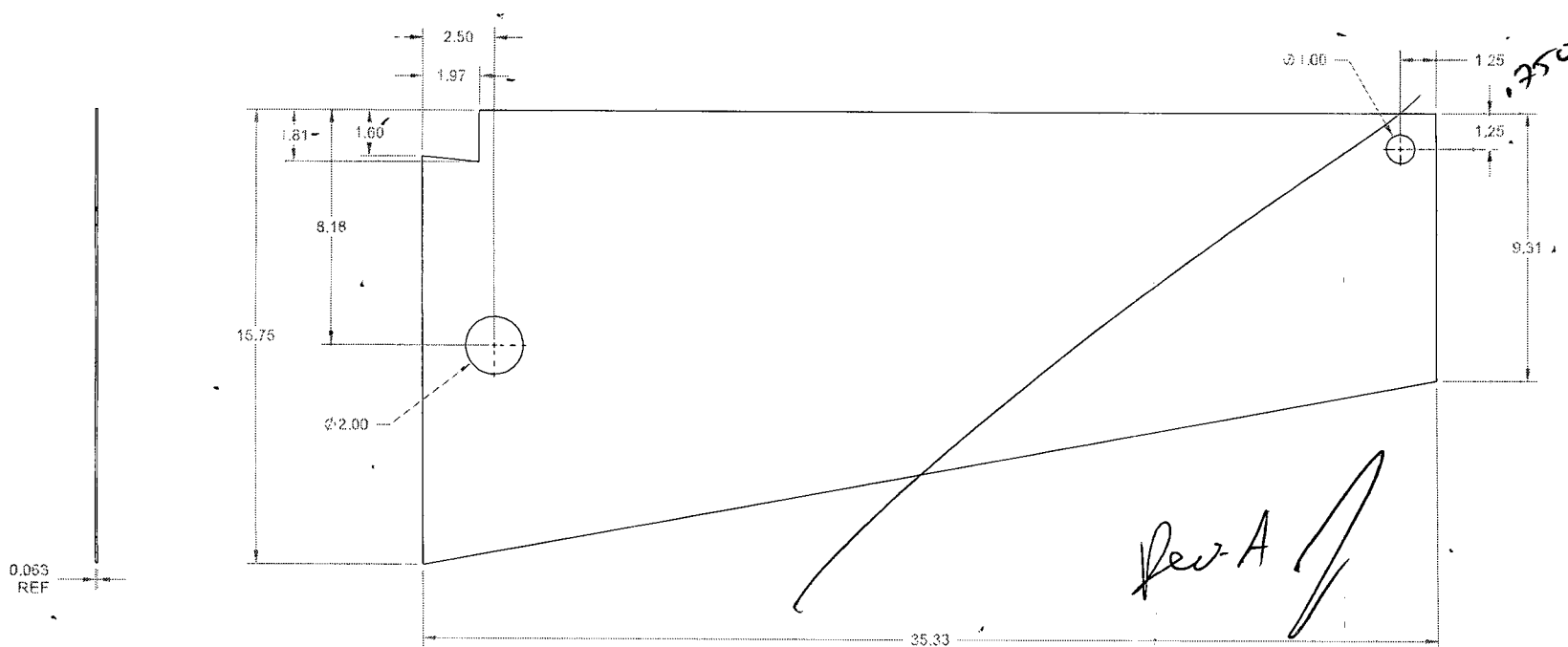
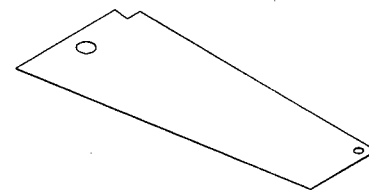
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-1P  Tank Top		Purchased	No			110	Each	0.0000	3.0000 		<i>2/11/20</i>	

POSITIVE RECALL

EFFECTIVE *10-22-08* AUTH *LA*

RELEASED *[Signature]* DATE *10-26-23* Qty 2

55963



D4055-1 TANK TOP

PRELIMINARY ISSUE

10.01.11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSL 005
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. PA1
MFG. APPR.			SHEET 5 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.01.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



180 AVENUE LABROSSE
POINT-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO. - MO.	AN. - YR		
02	03	10	0433551	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
DART GFI-0299	0210449	PO11330	

QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION
3	D4055-1P	TANK TOP CERTIFICATE OF CONFORMANCE REQ
MFG. JOB# J0210449 - 001 QTY 3 (1) BOX		



REÇU PAR / RECEIVED BY

DATE

EXPÉDITEUR
SHIPPER

N° DE BON DE LIVRAISON
SHIPPING MEMO NO.



TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

6/15/08

CERTIFICATE NO. <u>1</u>		OUR JOB NO <u>J0210449</u>		SHIPPING MEMO <u>0433551</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>---</u>	<u>3 PCS</u>	<u>PO11330</u>	<u>D4055-1P</u>		<u>TANK TOP</u>
MATERIAL		SUPPLIED BY		MAT. REL NO	
<u>AL 6061-T6</u>		<u>SAMUEL / ALCOA INC</u>		<u>608951</u>	
DWG ISSUE <u>PA1</u>					

#	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2	REF. GFI MANUFACTURING JOB NUMBER J0210449-001 (3 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 MARCH 2010

G.F.I. Q.C. REP. Dartan Hamlet





LES METAUX SPECIALISES SAMUEL
21525 CLARK-GRAHAM
BAIE D'URFE, QUEBEC, CANADA
H9X 3T5
(514) 457-3399 FAX (514) 457-9393

No 001591859



PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME
ASTERO TRANSPORT

CAMION/TRUCK
099

NOM DE LA BRANCHE/SALES BRANCH NAME
SAMUEL & FILS & CIE (QUEBEC) L

DATED/EXP/DATE OF SHIPMENT
2/16/10

VENDU À/SOLD TO:

GFI, DIVISION DE THOMAS & BETTS LTEE
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

(514) 630-4877

EXPÉDIÉ À/SHIP TO: TÀB: PPD

GFI INC.
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

CA

(201009-00001)

N° COMMANDE
N° ITEM
000752-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 76423
4 PCS AL. SH. 6061 T6
0630"x48"x144"
QQA 250/11

Cert/Test: FAX
174 LVR

#Pièce AS06348144QM

Description

Art

Pd ca

Qté

#Étiq

Vendeur Org

#Étiq mln

#À soul

4

192.000

174

Étq princ

#Coul

764479

4947487

ALR

US

Total:

4

192.000

174

D654824 608951

Poids total:

#Total paquets:

1

174 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ

LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ

CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX

SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS

RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

MÉLISSA DIAMOND
ADMINISTRATION

DATE 16/02/10



NIR: R-539477-1

FRL PAR ☒ PORT PAYÉ/REPAID ☐ PORT D'COLLECT

CHARGES

EXPÉDITEUR/DISPATCHER

INST. VOITURIER/DRIVER INSTRUCTIONS

VOITURIER/DRIVER

VALOR (\$2.00/lb max à moins d'avis contraire)
VALUATION (Max \$2.00/lb unless otherwise stated)
VALOR DÉCLARÉE DE L'EXPÉDITION
DECLARED VALUE OF SHIPMENT
REÇU PAR/RECEIVED BY

1. ORIGINAL - NON NÉGOCIABLE (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1058276 0
Ship Date B.L. No. Invoice No. Alcoa No. Item Page 1
2009-10-15 4303234 00000 1000143904-6 DCE-43904-6
P.O. No./Govt Contract No. Customer Alcoa Item
N22238 Ln#: 6 SAMUEL SON & CO LT G041110647R02

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
Q.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-
209 REV 07 EXC MRK ASTM B209 REV 07
CMMP025 REV S CMMP019 REV D ((MARKED))
KRAFT PAPER INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-30 %
CQR 0222751 REV 02 CUST REQ 09-10-
01 *** W/E 09-10-24 ***

8
10/09/08
D674827-3-4

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl	Inspector Clock Numbers
1	764477	608951	4119	100	PC	:	27299 47004
2	764478	608951	3408	83	PC	:	27299 47004
3	764479	608951	4149	100	PC	:	27299 47004
			11676	283			

Notes for CQR: 0222751.2
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISION DATED 1997-08-01.
CQR: 0222751.2 -Specification Limits

Temp Dir	UTS	TYS	EL4D										
T6 Long Transv.	KSI	KSI	PCT										
Max													
Min	42.0	35.0	10										
Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other			
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	Aluminum	
	Min	0.40		0.15		0.8	0.04					REMAIN	

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

[Signature]

Malcolm Murphy
Director of Manufacturing Davenport Works

[Signature]

Kenton P. Young
Quality Assurance Manager

1058276

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2009-10-15

4303234

00000

1000143904-6

DCE-43904-6

P.O. No./Govt Contract No.

Customer

Alcoa Item

N22238 Ln#: 6

SAMUEL SON & CO LT G041110647R02

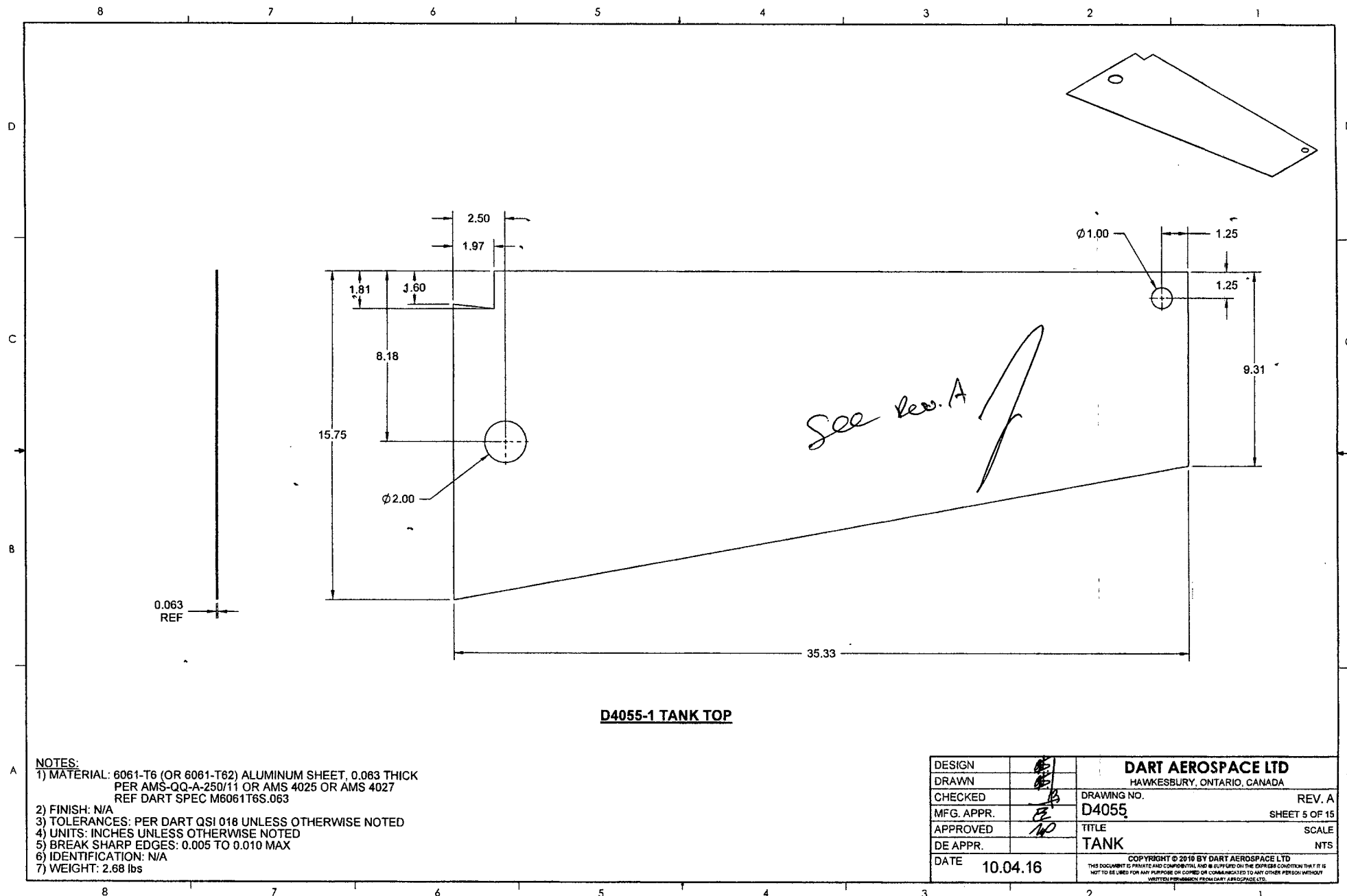
CQR: 0222751.2 -Specification Limits (cont.)
Lot: 608951

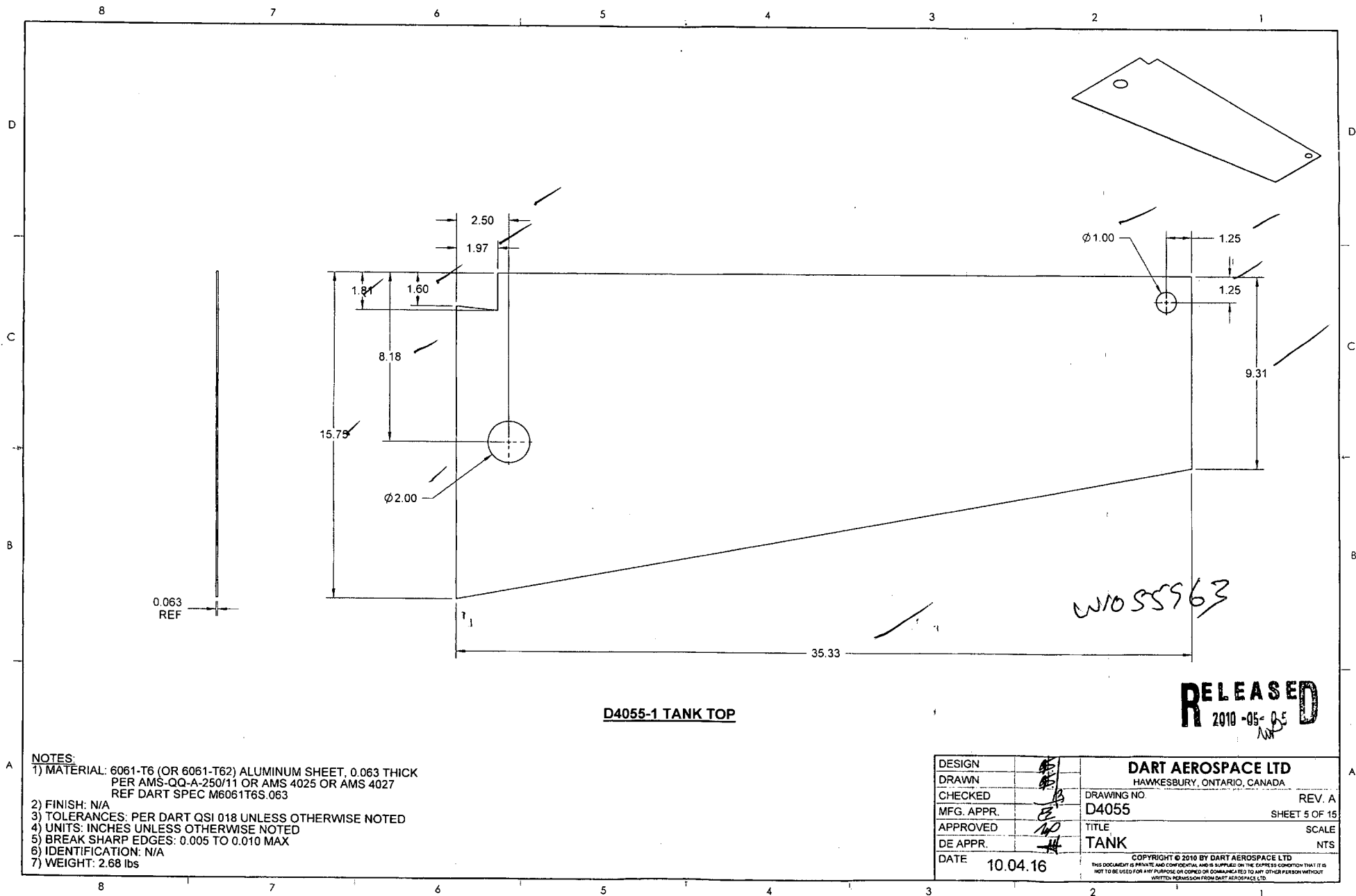
- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	50	44.8	10.9
			49.9	44.8	10.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H8054013	Actuals	0.66	0.5	0.26	0.06	0.9	0.19	0.05	0.02







This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States





NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 5 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries